

Work Order ID 96781

Monday, February 04, 2013 8:54:45 AM

96781

ASAP

Page 1

Item ID: D2986-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rubber Spacer
 Start Date: 2/4/2013 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 2/5/2013 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: JMF Date: 13-2-04 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2986	Rev B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2986 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control	***template DT3187-1T1***								
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

2 0 Jm 13-2-4
 4 0 Jm 13-2-5
 PTO →

2 0 Jm 13-2-4
 4 0 Jm 13-2-5

5

15
 13-2-4

31
1935

~~material had been marks in some locations.
Scrap + destroy.
Scrap qty x 1 gm
- Recut x 1 # 14935~~

Dart Aerospace Ltd

W/O: 96781		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2986-1 PAR #: Fault Category: water jet NCR: Yes ☒ No ☐ DQA: Date: 13/02/08
 Resolution: Disposition: Scrap QA: N/C Closed: Date:

NCR: 13-2304		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
13-2-5	116	material as hand burn marks in some locations QTV ①	DAS 16 2-09 as 1042 13/2/5	scrap and destroyed rent 4 B# 1141937	Jm 13-2-5	DAS 15 2-09 13-2-5	DAS 16 2-09 as 1042 13/2/5	DAS 16 2-09 13/2/5
		R-L Part moved on w/2 hole operat error		\$ 15.59				

NOTE: Date & initial all entries

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Item ID: D2986-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rubber Spacer

Start Date: 2/4/2013 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 2/5/2013 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: **CA**

0.00

130

Packaging

Memo

0.00

Packaging

MF**13-2-06**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/2/6**MF****13-2-04**

Picklist Print

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Page 1

Work Order ID: 96781

Parent Item: D2986-1

Parent Item Name: Rubber Spacer

Start Date: 2/4/2013

Required Date: 2/5/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B 09-01-20 rev.B as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4111NS.125		Purchased	No			100	sf	236.1800	5.466	11507368			
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4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Location

Loc Qty

Loc Code

MAT052

236.18

114937

236.18

114937.

Jm 13-2-4

D2986-1 RUBBER SPACER

Q 6781

14.88
REF

37.56
REF







52.90
REF

3.75
REF

NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET (ROLL), 0.125 THICK,
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
(REF. DART SPEC. M-4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.3 lbs
- 8) TOOLING: CUT PER TEMPLATE DT3187-1T1

RELEASED
09-01-06

B	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED PART DWG DETAIL; REVISED NOTE 1; REMOVED SUPPLIER AND SPEC DWG NOTES. REASON: ECN#08-589.	MB	08.12.18
A	NEW ISSUE	DS	00.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2986	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		RUBBER SPACER	NT
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